

Work Order ID 62227

Wednesday, September 22, 2010 3:15:53 PM

Page 1

Item ID: D3405-041

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 9/22/2010 Start Qty: 10.00

Required Date: 9/29/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date: 10-9-23

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

10-9-29

110

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-9-29

120

0.00

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

12

10-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

Revision ID:

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Start Date: 9/22/2010 Start Qty: 10.00

Required Date: 9/29/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Debur Form using DT8204 as per Dwg D3405	0.00 0.00	SB 10/10/25			(12)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(12)			
150  Large Fab Large Fab	Large Fab Memo Weld as per Dwg D3405 use DT9625 Identify as D3405-041	0.00 0.00	EL 10-11-25						(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries




Work Order ID 62227

Wednesday, September 22, 2010 3:15:53 PM

Page 3

Item ID: D3405-041 Accept  Setup Start 
Revision ID:
Item Name: Lug Assembly Stop 
Start Date: 9/22/2010 Start Qty: 10.00  Cust Item ID:
Required Date: 9/29/2010 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		<i>10-11-25</i>					
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Supervisor</i>		<i>(12)</i>			
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M115951</i> Memo START TIME: <i>3:40</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>4:10</i>	0.00 0.00				<i>12</i>	<i>12 10-11-25</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries




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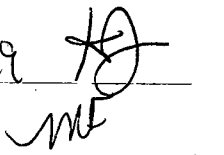
Page 4

Item ID: D3405-041 Accept  Setup Start 
Revision ID:
Item Name: Lug Assembly Stop 
Start Date: 9/22/2010 Start Qty: 10.00  Cust Item ID:
Required Date: 9/29/2010 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10/11/26		12	0		
200  Packaging Packaging	Identify as per dwg & Stock Location: 474 Memo	0.00 0.00							
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

 12

CK 10/11/26 
ME
10-11-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, September 22, 2010 3:15:56 PM

Page 1

Work Order ID: 62227

Parent Item: D3405-041

Parent Item Name: Lug Assembly

Start Date: 9/22/2010


Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.01 ☐ New issue ☐ KJ/JLM ☐
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1  GHW Lug		Manufactured	No			100	Each	5.0000	1	10			
--	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

B62219 x 12

Location

Loc Qty

Loc Code

WA

5

60858

5

M304S11GA

Purchased

No

150

sf

64.7423

0.154

1.621053

2.



304/316 0.125 Sheet

B10-9-29

Location

Loc Qty

Loc Code

MAT

64.7423

114799

64.7423

114799

(12)

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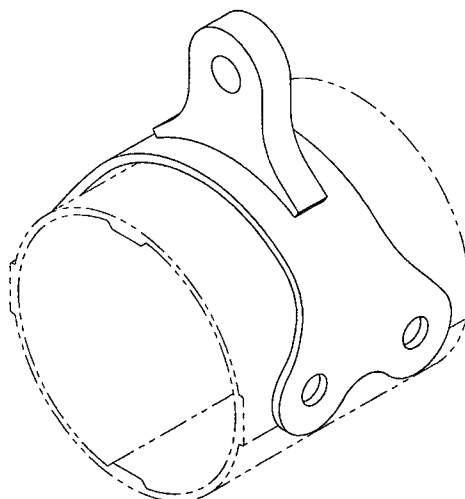
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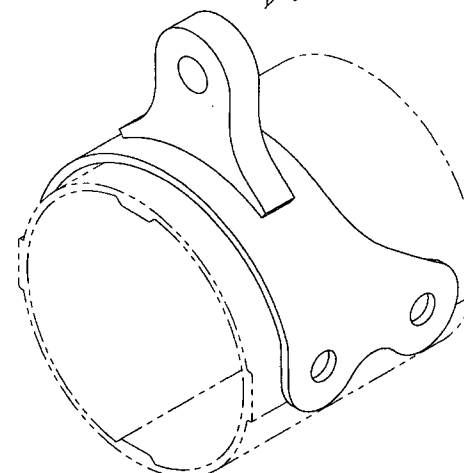
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



SHOP COPY
RETURN BY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *62227* *BSJO-923*



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO 'B' SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO. D3405	REV. B	
MFG. APPR.		SHEET 1 OF 4		
APPROVED		TITLE GHW LUG ASSEMBLY	SCALE	
DE APPR.		NTS		
DATE	08.09.19		<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

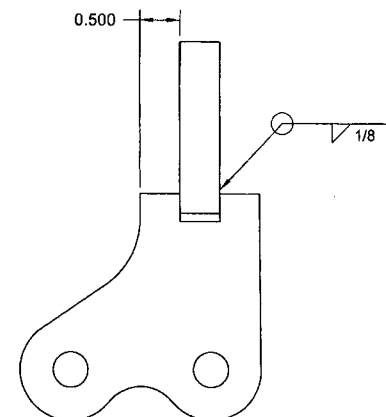
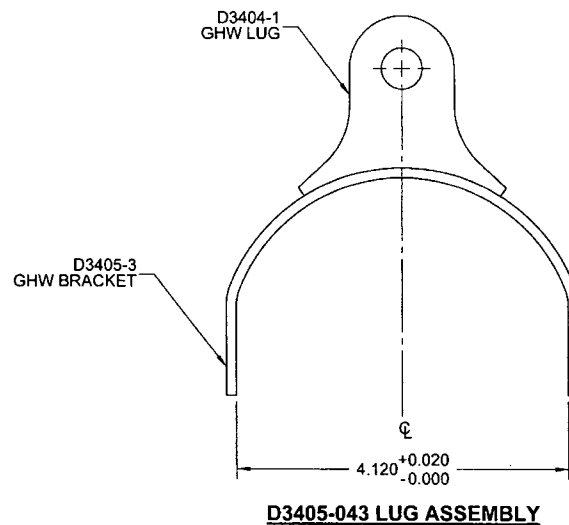
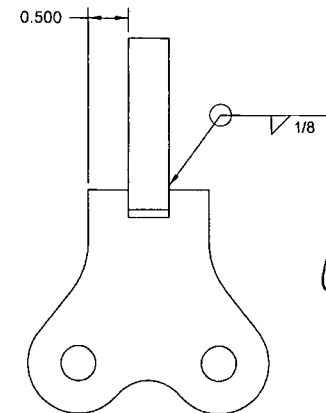
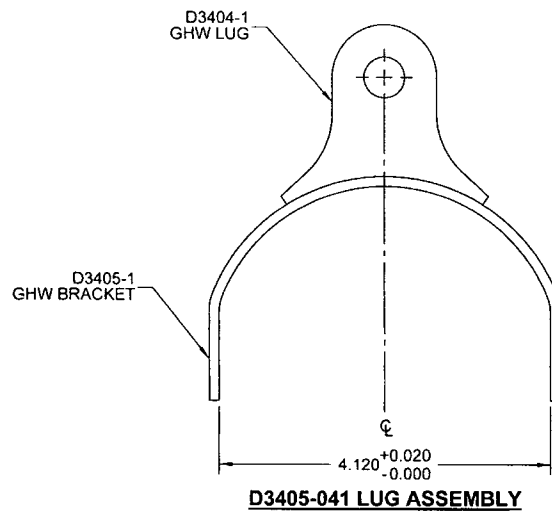
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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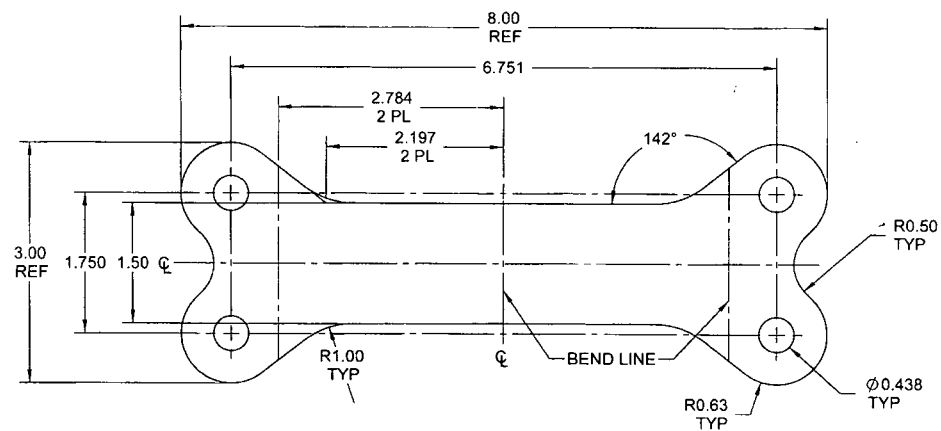
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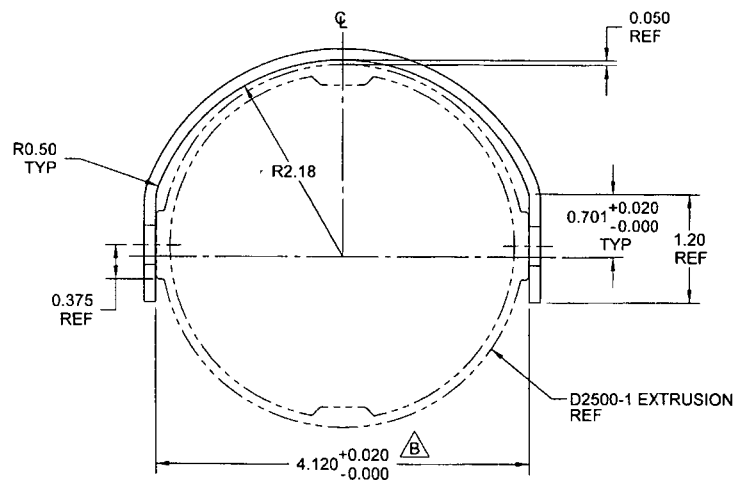
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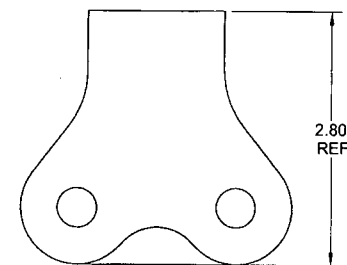
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SCALE NTS
APPROVED		DATE 08.09.19	
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08/09/19

celo 42227

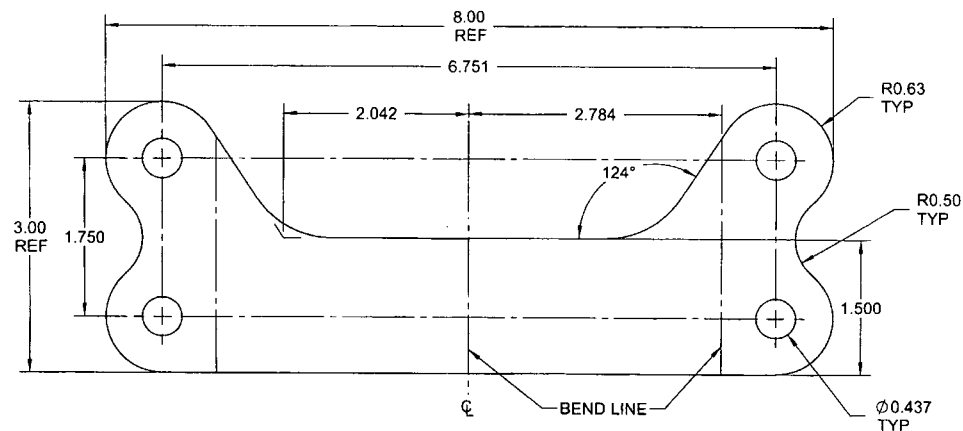
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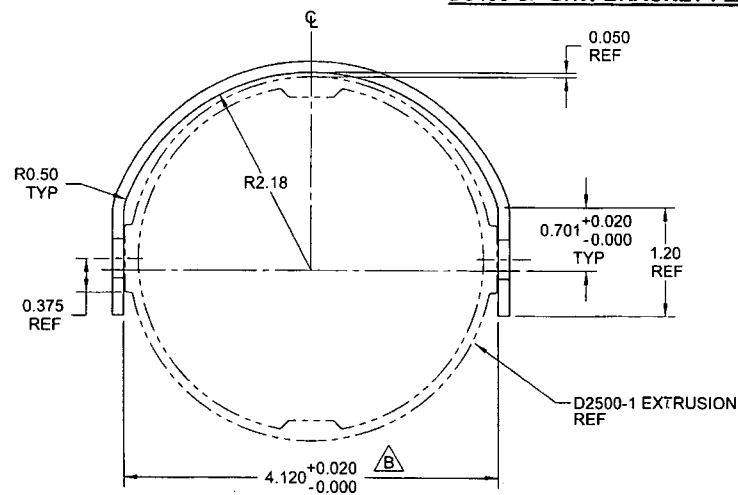
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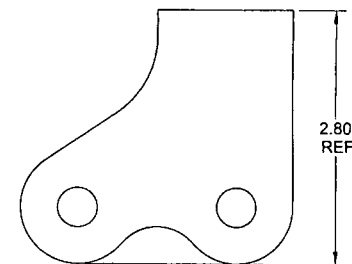


w/b 62227

D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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08/12/18 NV

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